

Date: Friday, 26/01/2007 1:59:12 PM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 30485	Part Number	: D29322
Estimate Number	: 10832	Drawing Number	: D2932 UNDER REVIEW <i>BK</i>
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 26/01/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: B
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Due Date	: 12/02/2007
Previous Run	: 29343	Qty:	<i>6</i> Um: Each
Written By	: <i>h</i>		
Checked & Approved By	: <i>h</i>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: *323349*

*SD*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

*SD 07.01.27*

*(6)*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

*M8*

*07/02/03*

*6*

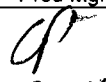
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*SD 07.01.27*

*(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/01/26	2	TOOL RHD FOR FLANGE RCKETS SHOULD BE RD.188				 07/01/26 J. Smith	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 07/02/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 30485

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 02/02/05 6*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*a.m 02/02/05 (6)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*N/10314/ ATTN: paint 1pc grey*

*m-l/y 07/02/09 (5X)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*02/02/12 (6)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *stgru*

*5 WMTK 1 grey*

*02/02/12 (6)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*02/02/13 (6)*

Job Completion



*u 02.02.12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	30485
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2932-2
<b>Inspection Dwg:</b> D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.123	.122	.120		
B	0.100	0.140		.125	.123	.122	.121		
C	0.100	0.140		.127	.120	.119	.119		
D	0.210	0.230		.220	.219	.218	.218		
E	1.245	1.255		1.250	1.256	1.256	1.256		
F	1.245	1.255		1.258	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.317	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.119	.119		
O	0.540	0.560		.549	.550	.549	.551		
P	0.490	0.510		.496	.497	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.253	.251	.251	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.125	1.145		1.133	1.133	1.132	1.131		
Y	1.565	1.585		1.571	1.571	1.570	1.570		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07.01.27

Audited by:	[Signature]
Date:	07/02/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

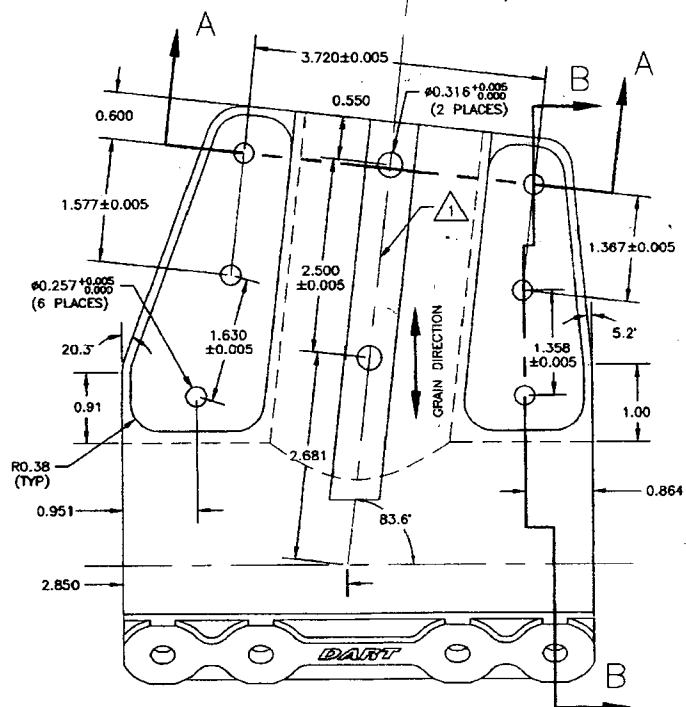
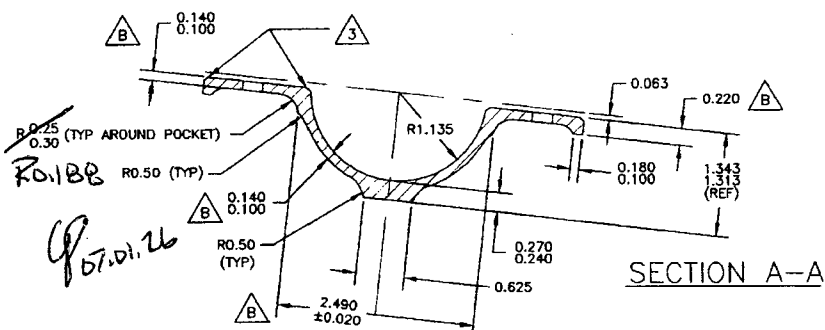
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30485
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> A2932-2
<b>Inspection Dwg:</b> L D2932 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

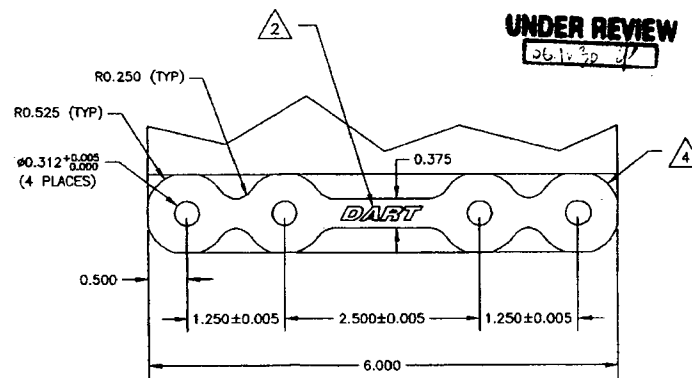
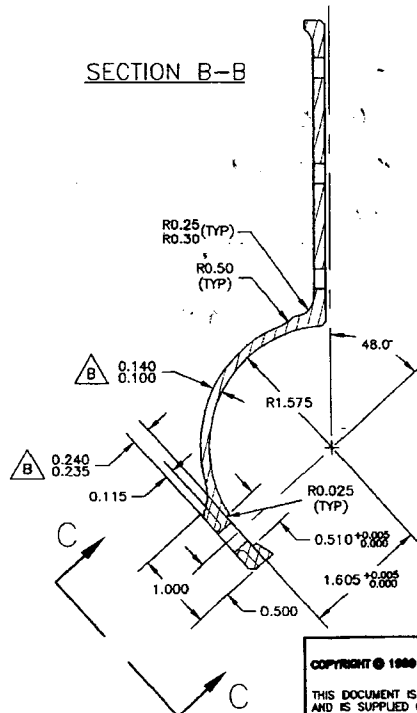
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.119				
B	0.100	0.140		.120	.120				
C	0.100	0.140		.119	.118				
D	0.210	0.230		.219	.218				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.510	0.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262	DT8683	.258	.258				
L	0.312	0.317	DT8686	.314	.314				
M	0.235	0.240		0.240	0.240				
N	0.100	0.140		.118	.119				
O	0.540	0.560		.550	.540				
P	0.490	0.510		.498	.498				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.252	.253				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.320	.320				
X	1.125	1.145		1.133	1.133				
Y	1.565	1.585		1.571	1.571				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: JML
Date: 07.01.28	Date: 07/02/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED



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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY RF	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE	00.05.29	TITLE SADDLE OUTSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

C207101124  
WLO 30485



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Chris Provencal**

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** October 19, 2006 3:31 PM  
**To:** 'S Shahbazian'  
**Cc:** 'Provencal, Chris'; 'Charbonneau, Eric'  
**Subject:** RE: Radius dimension on the saddle  
**Importance:** High

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.  
See D2661 to D2668 as well as D2932 to D2933.

David

---

**From:** S Shahbazian [mailto:sshahbazian@dartaero.com]  
**Sent:** Thursday, October 19, 2006 1:16 PM  
**To:** Shepherd, David  
**Cc:** Provencal, Chris; Charbonneau, Eric  
**Subject:** Radius dimension on the saddle

Dave,  
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

--  
No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

--  
No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

26/01/2007